

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003615**Date Inspected:** 31-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Huang Wen-Peng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

UT

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector received notification of witness inspection request numbers 768 from ZPMC QC department for UT verification. This QA inspector performed UT verification after ZPMC had completed and accepted the weldments in the OBG bay 7 for the following locations; FB010-007-043, FB010-008-043, FB015-007-043, FB012-004-043 and FB002-005-043. This QA inspector performed 10 % of the weld lengths for review and at the time of the QA review the weldments appeared to be in conformance. A TL-6027 will be generated for these locations.

Bay 7

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector observed ZPMC in process of fabrication on floor beams at various stages. They include Submerged Arc Welding (SAW) process for web plates on FB003-080-006 with welder Duan Xiuzhi under WPS-B-T-2221-L2c-S-2. Flux Cored Arc Welding (FCAW) process for FB033-001-125 & 126 placing 6mm fillet welds by welder Wang Chang Fa under WPS-B-P-2112-FCM for the stiffener to web plate connections. Shielded Metal Arc Welding (SMAW) process was being used by welder Yang Gen Cheng under WPS-B-P-2112 with electrode E7018 4mm diameter for tack welding. ZPMC had CWI Huang Wen-Pang present in this bay for the monitoring of the welding parameters and in process progression of fabrication.

Summary of Conversations:

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco , 1-381-694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Riley,Ken	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
